

Date: Thursday, 3/23/2006 3:52:04 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SADDLE FITTING, AFT (OUTBOARD/INBOARD)
<b>Job Number</b> :	26363		
<b>Estimate Number</b> :	10534		
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D2574
<b>This Issue</b> :	3/23/2006	<b>S.O. No.</b> :	N/A
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2574 REV E
<b>First Issue</b> :	3/23/2006	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	25999	<b>Drawing Revision</b> :	E
	<b>Type</b> :	<b>Material</b> :	N/A
	MACHINED PARTS	<b>Due Date</b> :	4/10/2006
<b>Written By</b> :	<i>See comment below</i>		<b>Qty:</b> 6 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	<i>06.03.24</i>		
<b>Comment</b> :	Est Rev: I As Per RevE 06-01-27 JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	D6101005	7075-T7351 8.25X5.0X2.5
-----	----------	-------------------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

7075-T7351 8.25X5.0X2.5

Make from D6101-005 billet for D2574

Ensure that grain is along 5.00" length

Batch No: *1324069*

X 6

*En 06/03/29*

(6)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------

**Comment:** HAAS CNC VERTICAL MACHINING #1Program Batch No. *826363* Double check by: *JS-L*

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

*JS/En**06/03/30 6*

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------

**Comment:** CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 &amp; D2574

*En 06/04/01*

(6)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE*JS/En**06/03/30 6*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 2 Date: 06/04/10  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 3/23/2006 3:52:04 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 26363

Part Number: D2574

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*gm 06/04/02*

*6*

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*a-m 06-04-04*

*(6)*

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*a-m 06-04-04*

*(6)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*DL 06/04/05*

*(6)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *479*

*R 4/4/6*

*(6)*

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*DL 06/04/07*

*(6)*

Job Completion



*U. 06/04/07*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 26363
<b>Description:</b> Saddle, Aft Inboard	<b>Part Number:</b> D2574
<b>Inspection Dwg:</b> D2574 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.748	1.748	1.746	1.747		
C	3.495	3.505		3.498	3.498	3.497	3.496		
D	1.745	1.755		1.748	1.748	1.746	1.747		
E	7.990	8.010		8.003	8.003	8.004	8.006		
F	0.490	0.510		0.494	0.495	0.501	0.504		
G	0.257	0.262	DT8683	0.258	0.258	0.257	0.257		
H	0.375	0.380	DT8684	0.376	0.376	0.375	0.375		
I	0.490	0.510		0.493	0.494	0.498	0.499		
J	1.174	1.184		1.177	1.177	1.177	1.177		
K	0.558	0.578		0.569	0.568	0.568	0.566		
L	1.174	1.184		1.177	1.177	1.177	1.177		
M	1.365	1.375		1.371	1.371	1.369	1.368		
N	2.495	2.505		2.498	2.499	2.496	2.497		
O	4.119	4.129		4.122	4.122	4.122	4.124		
P	0.115	0.135		0.126	0.126	0.126	0.126		
Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.240	0.248	0.258	0.257		
S	0.115	0.135		0.123	0.124	0.121	0.121		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.240	3.240		
V	0.230	0.250		0.232	0.237	0.235	0.241		
W	0.115	0.135		0.134	0.135	0.135	0.130		
X	0.307	0.312		0.311	0.310	0.310	0.310		
Y	0.760	0.765		0.761	0.761	0.760	0.760		
Z	0.352	0.372		0.362	0.361	0.372	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.623	0.624	0.624	0.623		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.240	0.249	0.254	0.255		
AE	1.500	1.520		1.510	1.511	1.511	1.505		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.240	0.241	0.258	0.259		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.033	0.033	0.030	0.030		
Accept/Reject									

Measured by: J.G.
Date: 06/03/30

Audited by: JMK
Date: 06/04/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 26363
<b>Description:</b> Saddle, Aft Inboard	<b>Part Number:</b> D2574
<b>Inspection Dwg:</b> D2574 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438				
B	1.745	1.755		1.747	1.746				
C	3.495	3.505		3.497	3.496				
D	1.745	1.755		1.747	1.746				
E	7.990	8.010		8.005	8.006				
F	0.490	0.510		0.499	0.502				
G	0.257	0.262	DT8683	0.257	0.257				
H	0.375	0.380	DT8684	0.375	0.375				
I	0.490	0.510		0.504	0.500				
J	1.174	1.184		1.178	1.178				
K	0.558	0.578		0.568	0.568				
L	1.174	1.184		1.178	1.178				
M	1.365	1.375		1.369	1.370				
N	2.495	2.505		2.497	2.497				
O	4.119	4.129		4.123	4.123				
P	0.115	0.135		0.127	0.127				
Q	0.115	0.135		0.130	0.130				
R	0.240	0.260		0.258	0.257				
S	0.115	0.135		0.123	0.120				
T	0.178	0.198		0.188	0.188				
U	3.210	3.250		3.240	3.240				
V	0.230	0.250		0.237	0.236				
W	0.115	0.135		0.123	0.125				
X	0.307	0.312		0.310	0.310				
Y	0.760	0.765		0.760	0.760				
Z	0.352	0.372		0.365	0.367				
AA	0.470	0.530		0.500	0.500				
AB	0.615	0.635		0.624	0.625				
AC	0.053	0.073		0.063	0.063				
AD	0.240	0.260		0.255	0.255				
AE	1.500	1.520		1.509	1.509				
AF	0.115	0.135		0.130	0.130				
AG	0.240	0.280		0.260	0.260				
AH	0.240	0.260		0.257	0.258				
AI	2.000	2.020		N/A	N/A				
AJ	0.023	0.043		0.030	0.030				
Accept/Reject									

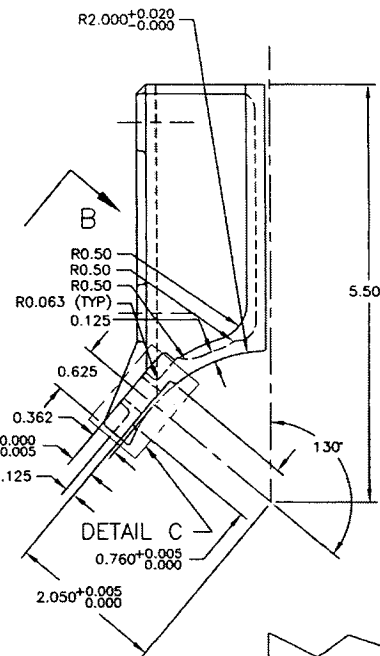
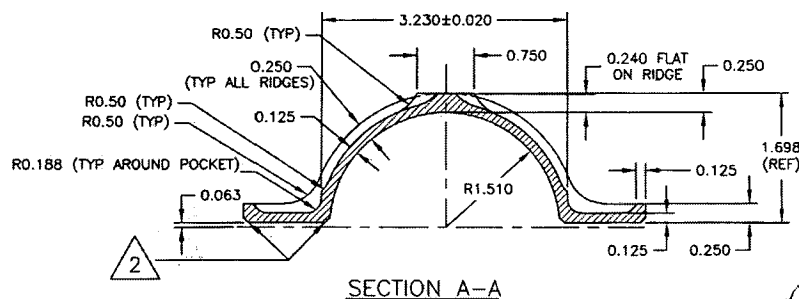
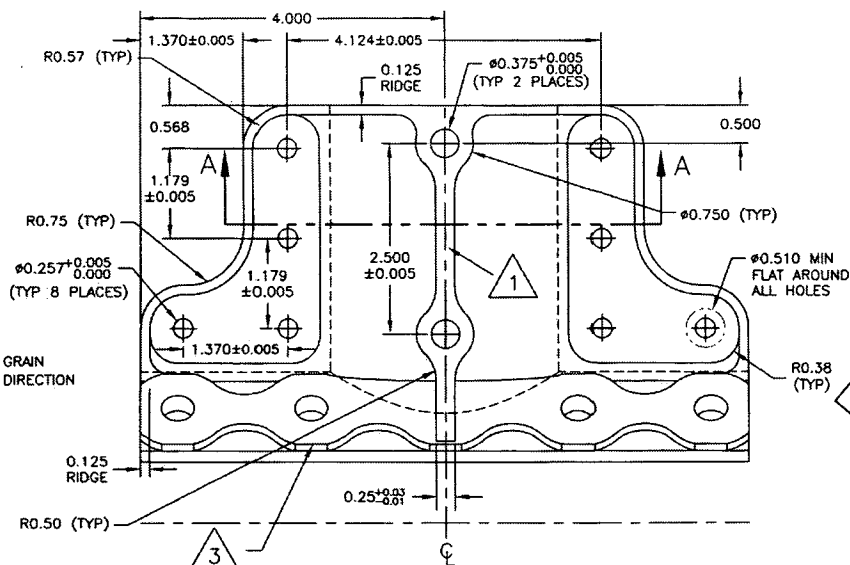
Measured by:	EP
Date:	06/04/01

Audited by:	ml
Date:	06/04/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

05.12.06

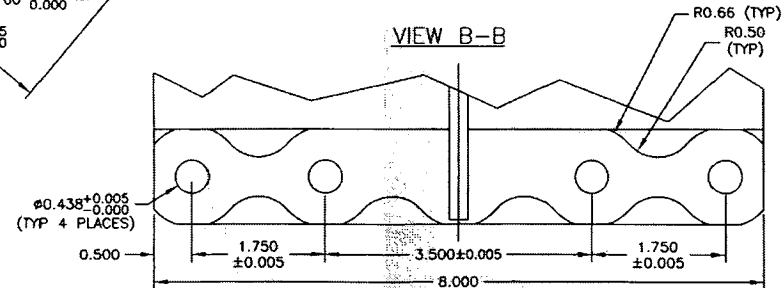


# NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)

## VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	APPROVED	DART
DATE	05.07.13	DRAWING NO. D2574
		TITLE INNER AFT SADDLE
		REV. E SHEET 1 OF 1 SCALE 2:3

COPYRIGHT © 2006 BY DART AEROSPACE LTD.  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL  
AND IS SUPPLIED ON THE EXPRESS CONDITION  
THAT IT IS NOT TO BE USED FOR ANY PURPOSE  
OR COPIED OR COMMUNICATED TO ANY OTHER  
PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

DETAIL C  
SCALE 2:1

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26363